

5/45

Split B

DART AEROSPACE LTD	Work Order:	24595B
Description: Blade	Part Number:	D2741
04.03.03 <i>kg LP</i>		
Drawing: D2741 Rev. B2	Qty:	10

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	<i>SA</i>	05.10.18	10
2	METAL	Cut blanks 13.850" long +0.063" -0.000" Material: 4130 steel bar 0.50" x 3.00" Batch: <i>1718765</i>	<i>SA</i>	05.11.02	36
3	CNC CELL	Machine per folio FA108	<i>SA</i>	05.11.05	36
4	QC	Inspect Level 2	<i>SA</i>	05.11.05	36
5	QC	Inspect Level 8	<i>SA</i>	05.11.11	36
6	METAL	Deburr	<i>SA</i>	06/11/18	36
7	METAL	Bend per Dwg D2741	<i>SA</i>	05/11/21	36
8	QC	Inspect Level 5	<i>SA</i>	05.11.25	36
9	PURCHASING	Issue P/O: <i>00000218</i> Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required	<i>SA</i>	05/12/05	36
10	RECEIVING	Receive and Inspect for transit damage Ensure Test report or Certification attached -	<i>SA</i>	05/12/22	36
11	QC	Inspect Level 5	<i>SA</i>	05.12.21	36
12	FINISHING	Powder Coat White (Ref. 4.3.5.2) per QSI 005 4.3	<i>SA</i>	06/01/24	22
13	QC	Inspect Level 3	<i>SA</i>	06/01/25	22
14	STORES	Identify and stock	<i>SA</i>	06/01/25	22
15	EXPEDITING	Close W/O Cost / part	<i>SA</i>	06.01.25	22

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue	DS/CP	
B	99.03.22	Material hardened after counterbore	DM	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	
D	00.11.15	Removed P/O turning - in house process	EC	

RELEASED

EC 00.11.20